

Work Order ID 116523

116523

Page 1

April-17-14 7:47:29 AM

Item ID: D4836-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Leg Assembly, LH
 Start Date: 4/17/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-04-17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4836	<u>✓</u> <u>B</u> <u>C</u>	<u>14.06.18</u>							

110

0.00

110

Small Fab

Small Fab

Memo

0.00

ALIGN PILOT HOLES IN D4836-1 WITH PILOT HOLES IN D4869-1 AND
 D4808-041. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9958 AS PER DWG.

2 FF 14-08-06

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

DAS 38 9-89
 DAS 9 9-89

14/08/06

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Crosstube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Start Date: 4/17/14 Start Qty: 2.00 *2* Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130		0.00							
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130

Small Fab

Small Fab

Memo

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
WET AS PER DWG USE DT9958
A/R HYSOL BATCH: 17130458

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: SH131

Memo

0.00

0.00

2 88 DEC 02 2014

(2) DAS 38 9-89 DEC 02 2014

(2x) DAS 46 9-89 DEC 02 2014

cutsource

P/O: 26707

C214/12/03

x2

rec'd

2x SPIS-01-7.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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April-17-14 7:47:29 AM

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Page 3

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160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 1501-09ST 131 CR 1501-0814-12-0215-1-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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Picklist Print

April-17-14 7:47:32 AM

Page 1

Work-Order ID: 116523

116523

Parent Item: D4836-041

D4836-041

Parent Item Name: Aft Leg Assembly, LH

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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~~HL 20PB5-8~~

Purchased

No

Each

76.0000

8

HI 20PB5-8

Rivet

FF 14-08-06

X HL 32PB5-8

Location

Loc Qty

Loc Code

ST281

m129865

66

M128110

6

M128579

60

ST284

10

M128429

10

D4808-041

Manufactured

No

Each

0.0000

2

D4808-041

Rod End Bearing Assembly

B 116576

2

FF 14-08-06

D4836-1

Manufactured

No

Each

0.0000

2

D4836-1

Strut

B 116524

2

FF 14-08-06

D4869-1

Manufactured

No

Each

2.0000

2

D4869-1

End Fitting, Eye

2

FF 14-08-06

Location

Loc Qty

Loc Code

ST131

B 116536

2

116167

2

2

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

April-17-14 7:47:32 AM

Page 2

Work Order ID: 116523

116523

Parent Item: D4836-041

D4836-041

Parent Item Name: Aft Leg Assembly, LH

Start Date: 4/17/14

Required Date: 5/02/14

Start Qty: 2.00

Required Qty: 2.00

HL86-5

Purchased

No

Each

133.0000

8

HI 86-5

FF 14-08-06

Collar

Location

Loc Qty

Loc Code

ST280

1129864

33

M128110

33

ST284

100

M128228

100

8

April-17-14 7:47:32 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26707**

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 2 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total:

\$8.

4 116521

D4835-041 LEG
ASSEMBLY

12/5/2014

4.00

\$4.00

\$16.

Yes

12/5/2014

LASER MARKED

Line Total:

\$16.

5 116523

D4836-041 LEG
ASSEMBLY

12/5/2014

2.00 ✓

\$4.00

\$8.

Yes

12/5/2014

LASER MARKED

GP15-01-7

Line Total:

\$8.

6 121529

D4836-041 LEG
ASSEMBLY

12/5/2014

2.00

\$4.00

\$8.

Yes

12/5/2014

LASER MARKED

Note:

12/3/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Dec 22, 2014

P.O NUMBER P026707

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4802-041 LEG ASSEMBLY 2 ALL ITEMS HAVE BEEN LASER MARKED

D4804-041 BIPOP ASSEMBLY

D4834-041 LEG ASSEMBLY

D4835-041 LEG ASSEMBLY

D4836-041 LEG ASSEMBLY

D4836-041 LEG ASSEMBLY

D4866-041 LEG ASSEMBLY

D4866-042 LEG ASSEMBLY

D4866-042 LEG ASSEMBLY

D4867-041 LEG ASSEMBLY

D4878-041 LEG ASSEMBLY

D4880-041 LEG ASSEMBLY

D4881-041 LEG ASSEMBLY

D4881-042 LEG ASSEMBLY

SP15-017